120

QC8- Inspect parts - second check

Memo

0.00

2) 507(7/29



Page 1

QC

Quality Control

Quality Control

0.00

В

July 8, 2009 1:43:53 PM

Item ID:

D3065-5

Revision ID:

Item Name: Step Leg

Required Date: 07/15/2009

Start Date:

07/08/2009

Start Qty: 40.00 Req'd Qty: 40.00



Accept



Setup Start



Stop

Plan

Code

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

0.00

SPC (Y/N):

Date:

Date:

Draw

Rev.

Run

Reject

Qty

Start



Insp.

Stamp

Stop

Sequence ID/ **Work Center ID**

130

HandFinish

Hand Finishing

Operation Description

QC: _____

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours**

09-67-30

Draw

Number

Accept Qty

Reject

Number

140

Quality Control

QC3- Inspect Part Finish

Memo

0.00

BR 09-07-30

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

(40)

DART AEROSPACE LTD	Work Order:	
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	L					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16458	X			
15.750	+/-0.005	15,750	×			
2.250	+/-0.005	PK.6	X			
3.460	+/-0.005	3.460	يخ			
0.865	+/-0.005	.864	×			
6.020	+/-0.005	P10.2	79			
1.205	+/-0.005	1.707	مز			
3.484	+/-0.005	3 485	A			***************************************
0.871	+/-0.005	.873	*			
8.325	+/-0.010	8.336	Sea			
0.551	+/-0.010	,583,	V			
0.213	+0.005/-0.000	طالة.	×			
Ø0.128	+0.005/-0.000	. 133	*			

Measured by:	B	Audited by:	7	Prototype Approval:	N/A
Date:	9-7-78	Date:	cila by	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM LA	
С	06.06.23	Dwg Rev. changed	KJ/JLM 🛠	\(\(\sqrt{\pi} \) \(\lambda \)

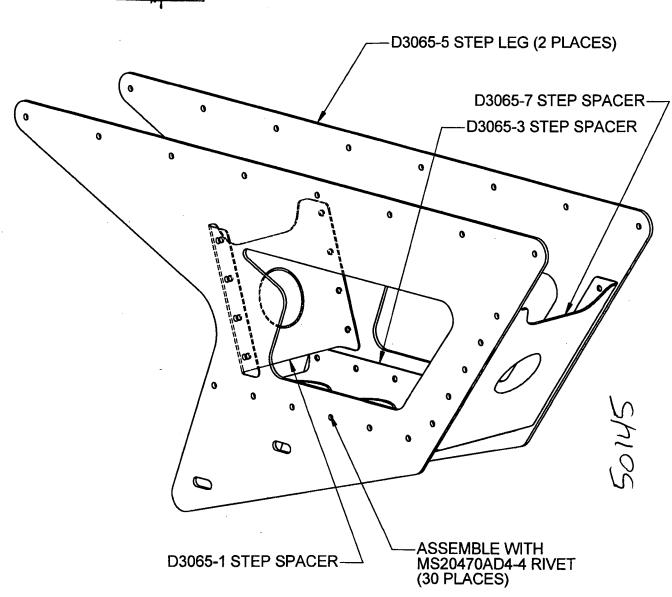
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W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PR	ROCEDURE CHANGE			,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	es N	o DQ .	A:	Date:	
		olution:								
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (N	ICR)				
5		Description of NC Corrective Action		Corrective Action Section	Section B			ration	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C	Sign & Section C		Chief Eng	QC Inspector
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DESIGN	4	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECK		APPROVED	DRAWING NO.	REV. B
	PH		D3065	SHEET 1 OF 5
DATE	00.0)E 00	TITLE	SCALE
	00.0	05.23	STEP LEG ASSEMBLY	1:2
Α	0	2.09.11	NEW ISSUE	
В	0	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS	TO D3065-5

RELEASED de de 20 4



D3065-041 STEP LEG ASSEMBLY

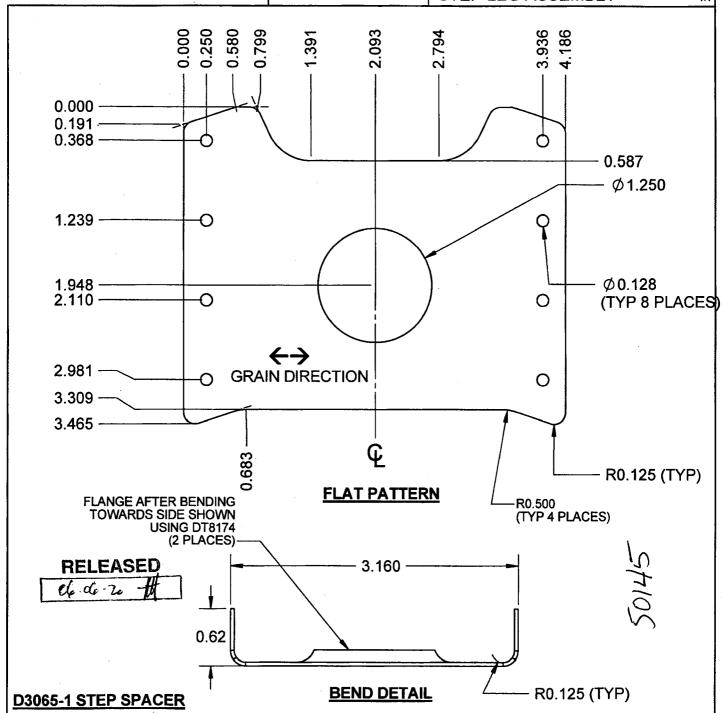
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	ļ								
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	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC	1	Corrective Action Section			cation Approval App		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
									1







- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

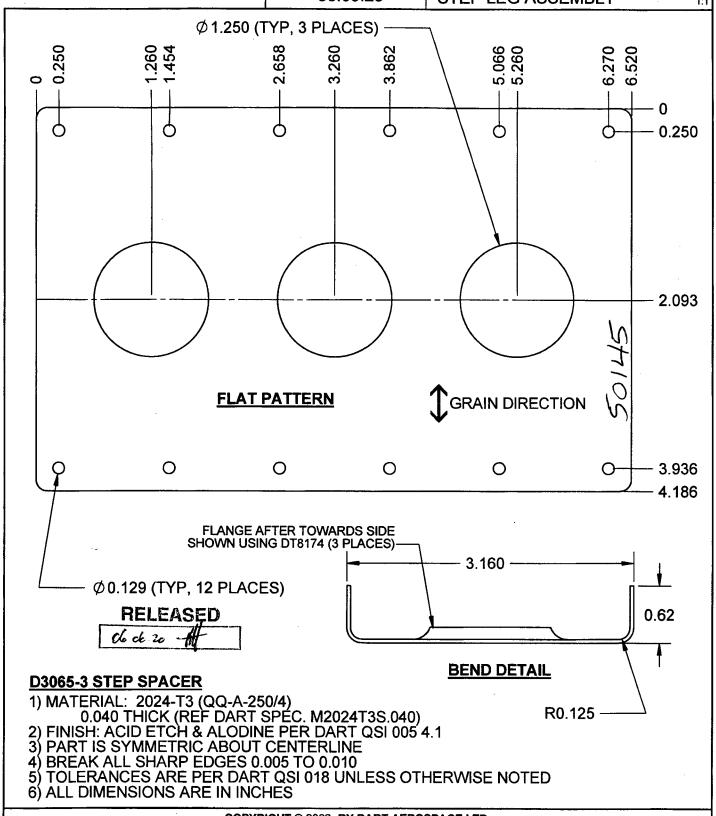
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W/O:			WC	RK ORDER CHANG	SES					
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo DQ /	4 :	Date:	
	R	esolution:	Disposition	n:	QA: N	/C Clos	sed:		Date: _	
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DATE	STEP	Description of NC Section A	Corrective Action S		tion B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
		Jection	Chief Eng	Chief Eng		Date	Secur	OH C	Crilei Eng	QC Inspector
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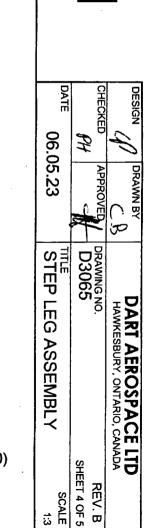




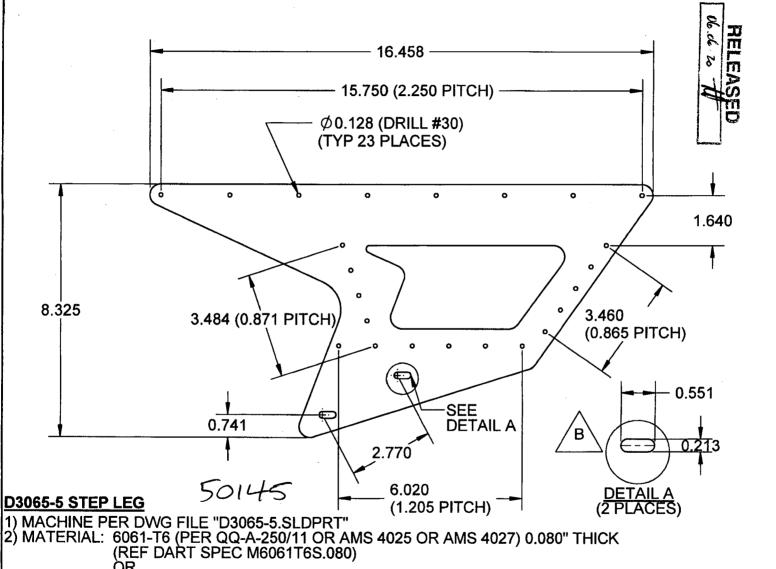
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W/O:			WC	ORK ORDER CHANGE	S				
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NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC			n B	Verific	fication	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	۱& ∣ _{Sect}	Section C	Chief Eng	QC Inspector



-34



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5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080) 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

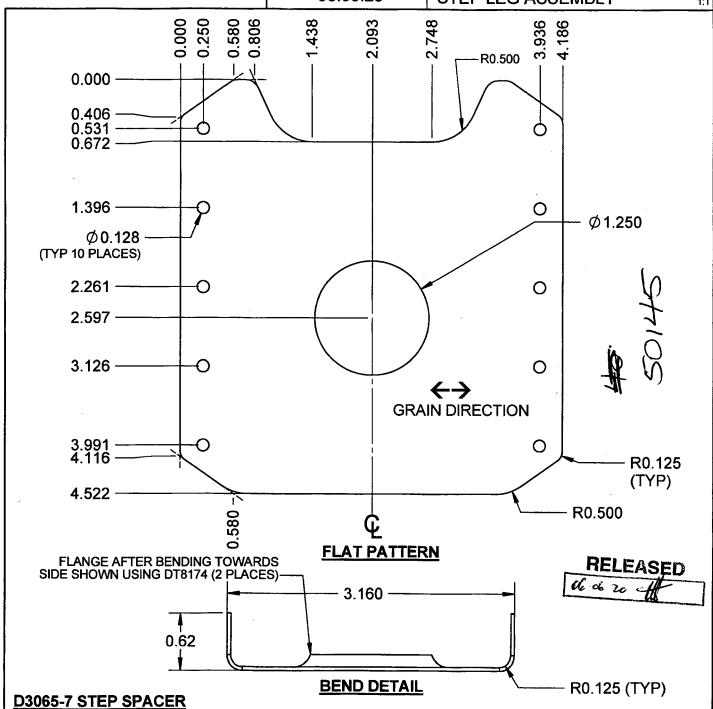
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

Dart	Aeros	pace	Ltd
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _		
		esolution:	Disposition:		QA: N/C CI	QA: N/C Closed:			Date:	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC	Corrective Action S Initial Action Description		tion B		erification	Approval	Approval	
	Section A		Chief Eng			Section C		Chief Eng	QC Inspector	
								·		
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- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040) 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:			WC	ORK ORDER CHANG	SES				
DATE	STEP	PROCEDURE CHANGE			Ву	Dat	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:	Fault Cate	gory:	_ NCR: Ye	es No	No DQA: Date: _		
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NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Description Chief Eng Chief Eng				erification Section C	Approval Chief Eng	Approval QC Inspector
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